

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004720**Date Inspected:** 20-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	N/A			<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Bridge No:</b>	34-0006			<b>Component:</b>	OBG		

**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Erik Prue was present to perform Ultrasonic Testing (UT) of Orthotropic Box Girder (OBG) components, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

**OBG Assembly Bay # 2**

Quality Assurance (QA) inspector arrived at ZPMC in Shanghai China for observation of Orthotropic Bridge Girders (OBG) and Self Anchored Suspension (SAS) Bridge. QA inspector received notification from day shift task leader to perform conventional Ultrasonic (A scan) Inspection for tack welds on deck panels. The inspection is preliminary prior to using the phased array system to verify indications found with conventional Ultrasonic testing. QA inspector performed UT on deck panel DP331-002, 4 ribs, 8 welds, 208 total tack welds inspected. Weld 1 scanned 26 locations with 15 indications, weld 2 scanned 26 locations with 14 indications, weld 3 scanned 26 locations with 17 indications, weld 4 scanned 26 locations with 9 indications, weld 5 scanned 26 locations with 15 indications, weld 6 scanned 26 locations with 13 indications, weld 7 scanned 26 locations with 19 indications, and weld 8 scanned 26 locations with 16 indications. All indications are marked on top of u-ribs. Please see U-rib Deck Panel Tack Weld Assessment report dated 20 November, 2008 for specific locations of indications.

QA inspector performed UT on deck panel DP331-001, 4 ribs, 8 welds, 208 total tack welds inspected. UT indications were marked on top of u-ribs with "Y" location. U-rib Deck Panel Tack Weld Assessment report dated 20 November, 2008 will be filed out by swing shift UT inspector showing specific locations of indications.

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## WELDING INSPECTION REPORT

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No other activities observed.

### Summary of Conversations:

No significant conversations this day.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Peter Dauterman, 15002199593, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Prue,Erik	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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